

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018344**Date Inspected:** 23-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Yu Dong Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower / OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #11

This QA Inspector observed the following work in progress

Tower

Submerged Arc welding (SAW)

Weld joint # 2 located on South shaft, Lift 6 Skin plate, SSD1-DPSA6-5. Welder is identified as 056975. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221-B-U3C-S-2.

Flux Cored Arc Welding (FCAW):

Weld joint # 7, 8 located on Lift 6 Skin plate ESD1-FDSA6 -2. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

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Weld joint # 1 located on Lift 6 Skin plate ESD1-FDSA6 -4. Welder is identified as 042218. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 2 located on Lift 6 Skin plate ESD1-FDSA6 -4. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

ORTHOTROPIC BOX GIRDER (OBG)

Flux Cored Arc Welding (FCAW):

Weld joint # 002, 007 located on Bike path BK004A6. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2332-TC-P4-F.

Weld joint # 001, 165, located on Bike path BK 004A6. Welder is identified as 040736. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 –Tc-P4-F.

Bay #10

Tower

Flux Cored Arc Welding (FCAW)

Weld joint # 2, 3 located on Lift 6 Skin plate to stiffener SSD1-FASA6 -1. Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 5, 6 located on Lift 6 Skin plate to stiffener SSD1-FASA6 -1. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

ORTHOTROPIC BOX GIRDER (OBG)

Flux Cored Arc Welding (FCAW):

Weld joint # 044 located on Bike path BK004A1-033. Welder is identified as 040458. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 –B –U2.

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Weld joint # 043 located on Bike path BK004A1-033. Welder is identified as 047353. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 –B –U2.

Weld joint # 003, 122 located on Bike path BK004A8 -030. Welder is identified as 052493. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114 .

Shielded Metal Arc Welding (SMAW):

Repair welding of Weld joint # 010, located on Bike path BK 004A -031. Welder is identified as 500363. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS –345 –SMAW -1G (1F) - Repair.

Tower Jetty

This QA Inspector observed an offset of approximately 6 mm between Lift 4 and 5 of South tower, Skin C. This has been photographed and reported to Task leader and SMR. Some photographs is attached with this report.

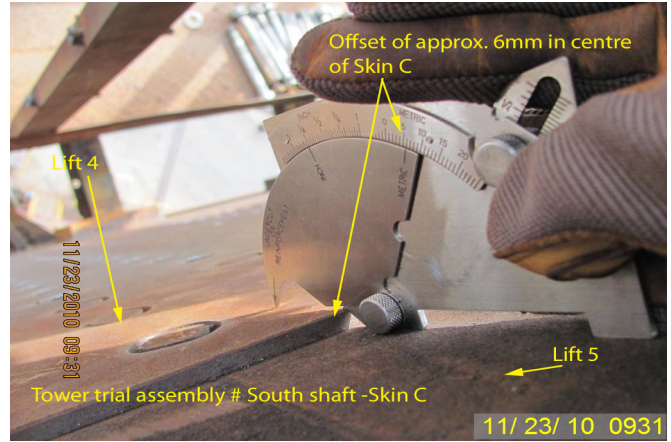
For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer